



EcoFlex NXT™ Carpet Tile

This Environmental Product Declaration (EPD) discloses potential environmental outcomes compliant with ISO 14025 for business to business communication.

The declared product is EcoFlex™ NXT back tufted carpet tile with solution dyed nylon 6 (SDN6) face fibre. It was made by Mohawk Industries at Glasgow, Virginia in The United States of America in 2017 for sale with a 10-year colourfast warranty for commercial residential and industrial floor coverings.

The world's largest flooring company Mohawk delivers stylish floor coverings for every residential and commercial application.

The company 2018 Sustainability Report shows Mohawk growing the global business while reducing the environmental footprint.

Mohawk is a recognized sustainability leader in environmental stewardship.

Responsible use of raw materials, recycling, waste management and water and energy conservation is a focus throughout its business and operations.

Across Mohawk is reaching its 2020 goals to decrease energy, greenhouse gas, water and landfill intensity by 25% since 2010

In 2018, Mohawk had 48 zero waste to landfill certified sites around the world recycling or reusing ≥90% of their factory waste

In 2018, they offered 100% recycled Polyester fibre carpet and rubber mats and carbon-neutral carpet and rugs.

Mohawk also maintains 2 National Wildlife Federation Certified Habitats, an apiary as well as 6 beehives to benefit ecosystems.

Glasgow site employees' Healthy Life Centre and health coaches enable their fitness goals.

The Mohawk Carpet Foundation supports charities and the >7kt pa carpet removed for customers is donated to charities

Visit www.mohawksustainability.com to learn more.



Figure 1 EcoFlex™ NXT Back Carpet



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Different program EPDs may not be comparable as e.g. Australian transport is more than elsewhere. **Further explanatory information is found at <http://www.globalgreentag.com/>** or contact: certification1@globalgreentag.com © This EPD remains the property of Global GreenTag Pty Ltd.



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1. Details of This Declaration

Program Operator	GreenTag Global Pty Ltd hereafter called Global GreenTag noted at www.globalgreentag.com
EPD Number	MK: EX NXT01-2019
Date issue	26 th September 2019
Validity	26 th September 2022
Reference PCR	Compliant with PCR: FC 2017
Time	Made in and sold from 2017 for 20 years use
Geography	Made in The United States of America. Uses are assumed as for Australasia.
Application	Commercial, Residential and Industrial building interior floor covering
Declared Unit	EcoFlex™ NXT backed tufted carpet with SDN6 face fibre /kg cradle to gate
Functional unit	EcoFlex™ 3.94 kg/m ² NXT SDN6 face carpet tile with 20-year use cradle to fate

2. Product Characterisation

Definition	EcoFlex™ NXT carpet tile flooring by Mohawk Industries Pty Ltd for all sectors
Standard	ASISO 9239.1-2003 Part 1: Reaction to Fire Tests for Floorings Determination of the Burning Behaviour using a Radiant Heat Source

3. Verification of this Declaration

This EPD was approved on 26th September 2019 according to requirements of ISO14025 8.1.3b.

Role	Name	Position	Signature
PCR Review Chair	Murray Jones	Ecquate Pty Ltd CEO	
LCA & EPD Developer	Delwyn Jones	The Evah Institute CEO	
3 rd Party LCI Verifier	Mathilde Vlieg	Vlieg LCA Consultant	
Internal EPD Audit	David Baggs	Global GreenTag CEO & Program Director	

4. Green Star® Certified Credits

Products are relevant to the Green Building Council of Australia’s (GBCA) Green Star® scheme. If required this EPD is evidence the declared product meets the following Green Star® credits. It may be used as evidence in Green Star® submissions for those credits. The product is certified by GBCA recognised Global GreenTag GreenRate to meet the following credits of Green Star®:

- Interiors V1.2: Sustainable Products, Indoor Pollutants
- Design and As Built V1.2: Sustainable Product, Indoor Pollutants
- Performance V1.2: Refurbishment Materials

GBCA Disclaimer

Green Star® is a registered mark of the Green Building Council of Australia (GBCA). Assessments shall not be reproduced in part at any time. Rating Tools and Technical Manuals are subject to change by the GBCA. This EPD provides Technical Opinion and as such is not endorsed by the GBCA or its agents. Green Star® Technical Manuals give technical details of credit requirements.



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5. Packaging, Installation, Use & Disposal

Packaging	Cardboard forms & cartons, plastic wrap & strapping on reused pallets.
Service life	Residential and commercial refits vary but 20-year life is assumed typical.
Health Safety & Environment	Apart from compliance to occupational and workplace health safety and environmental laws no additional personal protection is considered essential.
Residual Scrap	Mill off-cuts are not reused. Installation scrap of 5% is assumed to landfill.
Maintenance & Cleaning Scenario	The recommended cleaning and maintenance raise no ecosystem or human health concerns. Care and maintenance guides are on company websites. Weekly detergent spray, light mop, monthly wet machine scrub and cloth dry.
Recycling	Home mill, fabrication and installation scrap is reworked into new product.
Re-use	This study assumes 60% product is serviceable for reuse over 40 more years.
Disposal	It assumes 30% is recycled. Incineration is rare in Australia so none is modelled.

6. Whole of life Performance

Health Protection	The product does not contain levels of carcinogenic, toxic or hazardous substances that warrant ecological or human health concern cradle to grave. No issues or red-light concerns existed for product human or ecological toxicity.
Effluent Waste	The LCI results raised no red-light concerns in emissions to water ¹ . Cradle to grave waste to landfill was 1% hazardous and 99% non-hazardous.
Environmental Protection	Continuous improvement under the maker’s ISO14001 EMS aims to avoid toxics, waste and pollution plus reduce their material and energy use.
Environmental Health Effects	Installed products are certified as having VOC’s compliant with Green Star® IEQ VOC credits for indoor environment ² quality credits. No other potential in-use impacts on environment or health are known.

7. Base Material Origin and Detail

Table 1 lists key components all form the USA by function, type, key operation and amount.

Table 1 Base Material

Function	Component	Production		% mass
Backing Fill	Limestone	Mine, Crush, Sieve & Haul	IL USA	>36 <41
Face Fibre	Nylon 6	Acquire, Refine, Polymerise	GA USA	>22 <27
Backing	Polyester/Propylene	Acquire, Refine, Polymerise	TX USA	>15 <20
Precoat Latex	Butadiene Acrylate	Acquire, Refine, Polymerise	GA USA	>8 <13
Precoat Fill	Limestone	Mine, Crush, Sieve & Haul	VA USA	>5 <10
Scrim	Fiberglass	Mine, Refine, Fuse, Spin, Cut	TN USA	>2 <3
Antioxidant	Butylphenyl Phosphite	Acquire, Refine, Polymerise	Germany	<0.1
Antistatic	Proprietary	Drill, Mine, Refine, Polymerise	GA USA	<0.1
Stain block	Proprietary	Acquire, Refine, Polymerise	GA USA	<0.1
Defoamer	Surfactant	Acquire, Refine, Polymerise	IN USA	<0.1
Thickener	Polyacrylate	Acquire, Refine, Polymerise	IN USA	<0.1

1 According with national standards in ANZECC Guideline for Fresh & Marine Water Quality (2000)

2 in accordance with national standards and practice



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8. Inventory And Impact Results

Figure 2 depicts the scope and operations from acquiring resources to end of life.

Table 2a shows key inventory results/m²; Table 2b lists inventory results of material use/m² and Table 2c shows Life Cycle Impact Assessment results/ m² for 20 years product use, all cradle to end of life.

Table 2a Inventory Results/m² Functional Unit

Material Input	Unit	
Product mass	kg/m ²	3.94
Fossil Fuel	MJ	202
Recovered Energy	MJ	3.2
Finite Feedstock	MJ	112
Nuclear Energy	MJ	11
Hydrogen Energy	MJ	0.21
Total Non-Renewable Energy	MJ	203
Biomass Fuel	MJ	2.3
Hydro Power	MJ	2.2
Geothermal	MJ	0.01
Solar Energy	MJ	0.89
Wave/ Tidal	MJ	1.1
Renewable Feedstock	MJ	5.3
Renewable Primary Energy	MJ	6.5
Gross Energy & Feedstock	MJ	335

Table 2b Material Input/m² Functional Unit

Material Input	Unit	Result
Embodied Water	klitre	1.2
Recycled Water	klitre	1.0

Table 2c Impact Results in Potentials/m² Functional Unit

Impact Potential	Unit	Result
Climate Change from Global Warming	kg CO _{2e100}	15.4
Depletion of Stratospheric Ozone	kg R11 _e	5.1E-09
Acidification of lands and waters	kg SO _{2e}	0.63
Eutrophication of waters	kg PO ₄ ^{3-e}	4.5E-02
Ecosystem Quality Damages	PDF*m ² *yr	1.8E-03
Human Health Damages	DALY	2.0E-04
Abiotic Resource Depletion of Fossil Fuel	MJ _{surplus}	18
Abiotic Resource Depletion of Minerals	MJ _{surplus}	0.49



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9. Supply Chain Modelling

Processes to acquire, refine, transport, fabricate, coat, use, clean, repair, reuse and dispose of metal, masonry, ceramic, timber, glass, plastic and composites are modelled. A flow chart in Figure 2 shows key product supply chain operations from cradle to fate. These include those of:

- Mining, extracting and refining resources to make commodities and packaging;
- Acquiring, cultivating, harvesting, extracting, refining produce and biomass;
- Fuel production to supply power and process energy and freight;
- Chemicals use in processing resources, intermediates and ancillaries;
- Process energy, fuel and freight of resources, intermediates and ancillaries;
- Use, cleaning, recoating, repair, recycling, re-use and landfill, as well as
- Infrastructure process energy transformed and material wear loss e.g. tyres.

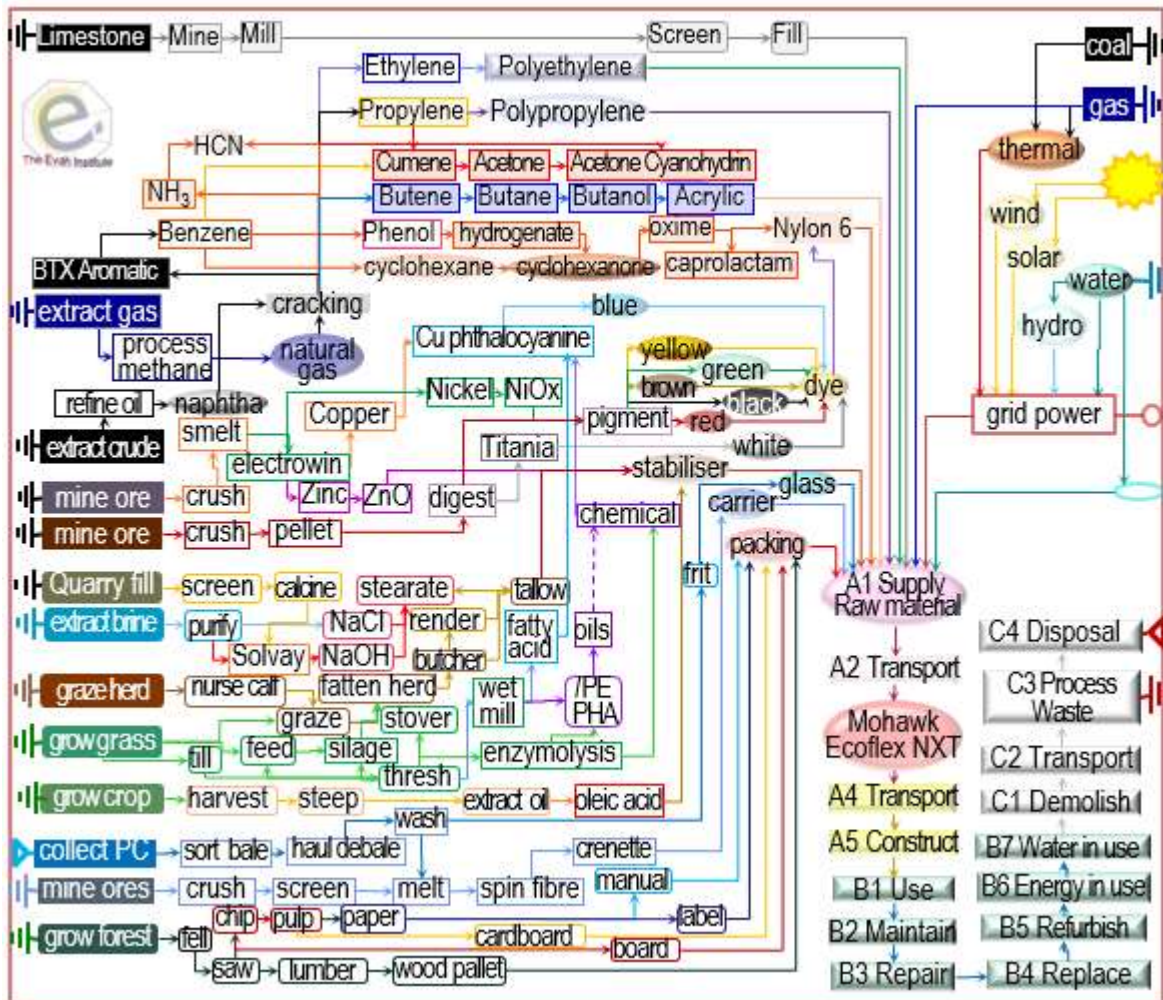


Figure 2 Major Product Operations



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10. Life Cycle Assessment Method

- LCA Author** The Evah Institute as described at www.evah.com.au
- Study Period** Factory data was collected from 2015 to 2018
- LCA Method** Compliant with ISO 14040 and ISO 14044 Standards
- LCIA method** EcoIndicator 99 Life Cycle Impact (LCIA) Assessment
- Scope** Cradle to Fate including all supply chain phases and stages depicted in Figure a.
- Phases** The LCA covered all known flows in all known stages cradle to end of life fate.
- Assumptions** Use is to typical Australian Facility Management professional practice.
- Scenarios** Use, cleaning, maintenance plus disposal and re-use were scenario-based using Facility Management Association denoted and published typical operations.
The LCA system boundary depicted in Figure a includes all operations
 - A1-A3 production with upstream supply & transport;
 - A4 package & deliver & A5 construct;
 - B1 use with cleaning, B2 maintain, B3 repair, B5 refurbish,
 - C1 demolish, C2 transport and C4 disposal
- System Boundaries** All significant resource acquisition, water, fuel & energy use, power generation & distribution, freight, refining, intermediates, manufacture, scrap re-use and goods inwards packaging are included cradle to gate. Cradle to Grave scope includes packing and dispatch as well as installation, use, maintenance, landfill waste and emission flows from all supply chain operations involved to make, pack and install repair and demolish product.
- Processes**



Modeling	Actual		Scenarios								Potential						
	Produce			Construct		Building Fabric & Operation					End of life				Beyond Boundary		
	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	C1	C2	C3	C4	D	1, 2	3
Phases	Resource supply			Transport		Use					Demolish				Reuse		
	Transport			Manufacturing		Maintain					Transport				Recovery		
Modules	Manufacturing			Construction		Repair					Process/Waste				Recycling		
	Transport			Construction		Replace					Disposal						
Unit Operations	Manufacturing			Construction		Refurbish					Disposal						
	Transport			Construction		B6 Operating Energy use					Disposal						
	B7 Operating Water use			Construction		Demolish					Disposal						
Cradle to Grave	Mandatory			Mandatory		Mandatory					Optional				Optional		
Cradle to Gate+options	each phase			each phase		each phase					Optional				Optional		
Cradle to Gate	each phase			each phase		Optional					Optional				Optional		

Figure a Phases and Stages Cradle to Grave

Evah industry databases cover all known domestic and global scope 1 and 2 operations. They exclude scope 3 burdens from capital facilities, equipment churn, noise and dehydration as well as incidental activities and employee commuting.

The databases exist in top zones of commercial global modelling and calculating engines. Electricity supply models in active databases are updated annually. As each project is modelled with new data the databases are updated and audited by external 3rd party verifiers. Quality control methods ensure:

- Coverage of place in time with all information for each dataset noted, checked and updated;
- Consistency to Evah guidelines for all process technology, transport and energy demand;
- Completeness of modeling based on in-house reports, literature and industry reviews;
- Plausibility in 2-way checks of LCI input and output flows of data checked for validity, plus
- Mathematical correctness of all calculations in mass and energy balance cross checks.



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11. Data Sources Representativeness and Quality

Primary data used for modelling the state of art of each operation includes all known process for:

- Technology sequences;
- Energy and water use;
- Landfill and effluent plus
- Reliance on raw and recycled material;
- High and reduced process emissions;
- Freight and distribution systems.

Primary data is sourced from clients, Annual Reports and their publications on corporate locations, logistics, technology use, market share, management systems, standards and commitment to improved environmental performance. Information on operations is also sourced from client:

- Supply chain mills, their technical manuals, corporate annual reports and sector experts, and
- Manufacturing specifications websites and factory site development license applications.

Background data is sourced from the International Energy Agency, IBISWorld, USGS Minerals, Franklin Associates, Boustead 6, Plastics Europe, CML2, Simapro 8, EcoInvent 3 and NREL USLCI model databases. Information on operations is also sourced from:

- Library, document, NPI and web searches, review papers, building manuals and
- Global Industry Association and Government reports on Best Available Technology (BAT).

For benchmarking, comparison and integrity checks inventory data is developed to represent BAT, business as usual and worst practice options with operations covering industry sector supply and infrastructure in Australia and overseas.

Such technology, performance and license conditions were modelled and evaluated across mining, farming, forestry, freight, infrastructure and manufacturing and building industry sectors since 1995.

As most sources do not provide estimates of accuracy, a pedigree matrix of uncertainty estimates to 95% confidence levels of Geometric Standard Deviation² (σ_g) is used to define quality as in Table a³.

Table a Data Quality Parameters and Uncertainty (U)

Correlation	Metric σ_g	U ±0.01	U ±0.05	U ±0.10	U ±0.20	U ±0.30
Reliability	Reporting	Site Audit	Expert verify	Region	Sector	Academic
	Sample	>66% trend	>25% trend	>10% batch	>5% batch	<1% batch
Completion	Including	>50%	>25%	>10%	>5%	<5%
	Cut-off	0.01%w/w	0.05%w/w	0.1%w/w	0.5%w/w	1%w/w
Temporal	Data Age	<3 years	≤5 years	<10 years	<15 years	>16 years
	Duration	>3 years	<3 years	<2 years	1 year	<1 year
Geography	Focus	Process	Line	Plant	Corporate	Sector
	Range	Continent	Nation	Plant	Line	Process
Technology	Typology	Actual	Comparable	In Class	Convention	In Sector

No data set with $\geq\pm 30\%$ uncertainty is used without notation in the LCA as well as the EPD.

³ Evah Institute data quality control system accords with UNEP SETAC Global LCI Database Quality 2010 Guidelines



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12. Supply Chain Modelling Assumptions

Australian building sector rules and Evah assumptions applied are defined in Table b.

Table b Scope Boundaries Assumptions and Metadata

Quality/Domain	National including Import and Export
Process Model	Typical industry practice with currently most common or best (BAT) technology
Resource flows	Regional data for resource mapping, fuels, energy, electricity and logistics
Temporal	Project & background data was collated 3 years to declaration approval date.
Geography	Designated client, site, regional, national, Pacific Rim then global jurisdiction
Representation	Designated client, their suppliers and energy supply chains back to the cradle
Consistency	Model all operations by known given operations with closest proximity
Technology	Typical of global or Pacific Rim supply chain 3 years to declaration approval date.
Functional Unit	Typical product with cleaning & disposal used for declared years' service life/m ²
System Control	
Primary Sources	Clients and supplier mills, publications, websites, specifications & manuals
Other Sources	IEA, USGS Minerals, IBISWorld, Boustead, Government & Industry reports
Data mix	Power grid & renewable shares updated to latest IEA & power generator reports
Operational	Company data for process performance, product share, waste and emissions
Logistics	Local data is used for power, fuel mix, water supply, logistics share & capacity
New Data Entry	VliegLCA, Evah Institute; Global Green Tag Researchers at declaration date.
Data Generator	Manufacturers, Evah Institute; GGT; Meta: IBIS, Other pre-publication date
Data Publisher	The Evah Institute Pty Ltd to Global GreenTag and designated client only
Persons input	All contributors cited in Evah & Global GreenTag records or websites
Data Flow & Mix	
System Boundary	Earth's cradle of all resource & emission flows to end of use, fitout or build life
System flows	All known from and to air, land, water and community sources & sinks
Capital inclusions	Natural stocks Δ , industry stockpiles Δ , capital wear Δ , system losses and use
Arid Practice	Dry technology adopted; Water use is factored by 0.1 as for e.g. Mining
Transportation	Distance >20% than EU; >20% fuel efficient larger vehicles, load & distance
Industrial	Company or industry sector data for manufacturing and minerals involved
Mining	All raw material extraction is based on Australian or Pacific Rim technology
Imported fuel	Mix is from nearest sources is e.g. UAE, SE Asia, Canada or New Zealand
Finishes	Processing inputs with finishing burdens are factored in. If not, that is denoted
Validation	
Accuracy	10 th generation study is \pm 5 to 15% uncertain due to some background data
Completeness	All significant operations are tracked and documented from the cradle to grave
Precision	Tracking of >90% flows applies a 90:10 rule sequentially to 99.9% and beyond
Allocation	%100 to co products on reaction stoichiometry by energetic or mass fraction
Burdens	All resource use from & emissions to community, air, lands & waters are included
Plausibility	Results are checked and benchmarked against BAT, BAU & worst practice
Sensitivity	Calculated U is reported & compared to Bath U RICE & EcoInvent libraries
Validity Checks	Are made versus Plastics Europe, Ecobilan, GaBi & or Industry LCA Literature

**EcoFlex NXT™ Carpet Tile****13. References for this LCA & EPD**

- Australian & New Zealand (ANZECC) Guidelines For Fresh & Marine Water Quality (2000) <http://www.environment.gov.au/water/quality/national-water-quality-management-strategy>
- Basel Convention (2011) Control of Transboundary Movement of Hazardous Waste & Disposal <http://www.basel.int/portals/4/basel%20convention/docs/text/baselconvention-text-e.pdf>
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- International Energy Agency (2016) Energy Statistics <http://www.iea.org/countries/membercountries/>
- ISO 9001:2008 Quality Management Systems Requirements
- ISO 14001:2004 Environmental management systems: Requirements with guidance for use
- ISO 14004:2004 EMS: General guidelines on principles, systems & support techniques
- ISO 14015:2001 EMS: Environmental assessment of sites & organizations (EASO)
- ISO 14020:2000 Environmental labels & declarations — General principles
- ISO 14024:2009 Environmental labels & declarations -- Type I Principles & procedures
- ISO 14025:2006 Environmental labelling & declarations Type III EPDs Principles & procedures
- ISO 14031:1999 EM: Environmental performance evaluation: Guidelines
- ISO 14040:2006 EM: Life cycle assessment (LCA): Principles & framework
- ISO 14044:2006 EM: LCA: Requirement & guideline for data review: LCI; LCIA, Interpretation results
- ISO 14064:2006 EM: Greenhouse Gases: Organisation & Project reporting, Validation & verification
- ISO 15392:2008 Sustainability in building construction General principles
- ISO 15686-1:2011 Buildings & constructed assets Service life planning Part 1: General principles
- ISO 15686-2:2012 Buildings & constructed assets Service life (SL) planning Part 2: prediction
- ISO 15686-8:2008 Buildings & constructed assets SL planning Part 8: Reference & estimation
- ISO 21929-1:2011 Sustainability in building construction Sustainability indicators Part 1: Framework
- ISO 21930:2007 Building construction: Sustainability, Environmental declaration of building products
- ISO/TS 21931-1:2010 Sustainability in building construction: Framework for assessment, Part 1:
- ISO 21932:2013 Sustainability in buildings and civil engineering works -- A review of terminology
- Plastics Europe (2016) Portal <http://www.plasticseurope.org/plastics-sustainability/eco-profiles.aspx>
- Pre (2016) SimaPro 8 Software, The Netherlands <http://www.pre-sustainability.com/simapro-manuals>
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- UNEP (2016) Persistent Organic Pollutants <http://www.chem.unep.ch/pops/> The UN
- USLCI (2016) Life-Cycle Inventory Database <https://www.lcacommons.gov/nrel/search>, USA
- U.S. Geological Survey National Minerals (2016) <http://minerals.usgs.gov/minerals/pubs/country/> USA
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14. Reviewers Report Conclusions

The independent LCA reviewer's report confirmed that the LCA project report and addition information addressed the EPD. The verifier was not involved in developing the LCA or EPD and has no conflict of interests from their organisational position.

While the report is confidential its conclusions confirmed that documentation according to set ISO Standard requirements was provided including evidence from the:

The Evah Institute, the LCA developer:

- a) Recipes of input and output data of unit processes used for LCA calculations ✓
- b) Datasheets of measures, calculations, estimates and emails with sources as in Table 6 ✓
- e) References to literature and databases from which data was extracted as noted in Table 6 ✓
- g) Notes on supply chain processes and scenarios satisfying requirements of this Standard ✓
- i) Embodied Energy shares as used for sensitivity analyses re ISO 14044:2006, 4.5.3.3 ✓
- j) Proof percentages or figures in calculations in the end of life scenario ✓
- k) Notes on proof of % and allocation calculations ✓
- o) All operations covered Vs criteria and substantiation used to determine system boundaries ✓

Product Manufacturer in:

- c) Specifications used to create the manufacturer's product ✓
- d) Citations, references, specifications or regulations & data showing completeness ✓
- f) Specification demonstrating that the building product can fulfil the intended use ✓

The Certifier Global GreenTag on:

- l) Notes and calculation of averages of different locations yielding generic data ✓
- m) Substantiating additional environmental information ISO 14025:2006, 7.2.4 ✓
- n) Procedures for data collection, questionnaires, instructions, confidentiality deeds ✓

Requiring No Evidence:

As the EPD is cradle to grave as well as PCR compliant the independent reviewer did not need to:

- h) Substantiate a few stages as all stages were substantiated ✓
- p) Substantiate alternatives when no other choices and assumptions were applied ✓
- q) Demonstrate consistency for few stages as the same rules in Tables 5 and 6 applied to all. ✓



EcoFlex NXT™ Carpet Tile

This Environmental Product Declaration (EPD) discloses potential environmental outcomes compliant with ISO 14025 for business to business communication.

Further and explanatory information is found at

<http://www.globalgreentag.com/>

or contact:

certification1@globalgreentag.com



Global GreenTag^{Cert}™ EPD Program

Environmental Product Declaration

Compliant to ISO 14025

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